

ABSTRACT OF THE DISCLOSURE

A method for cutting steel in which an operator uses high pressure propane and oxygen. The operator heats the steel locally until it is molten, positions a cutting torch with a high angle of incidence relative to the molten steel, and then blasts high pressure oxygen at the molten metal. Such blast serves two purposes, heating the molten metal so it is less viscous and then blowing the molten metal away from the steel sheet creating a cutting trench. The cutting torch is positioned relative to the cutting trench to provide even heat. The cutting torch is then moved generally parallel to the cutting trench to lengthen the cut.